











## Process Sheet

Customer : CC-DART Dart Aerospace Ltd.	Drawing Item : D2571/D2572/D2573/D2574
Job Number : 23374	Part Number : Z_CUSTOM
Part Number : 10304	Drawing Number : RTN465
P.O. Number : N/A	Project Number : N/A
This Date : 3/24/2003 S.O. No. : N/A	Drawing Revision : N/A
Print Date : NC	Material : N/A
First Date : N/A Type : N/A	Due Date : 3/31/2006
Previous Date : 00015	Qty: 1 Um: Each
Written By : _____	
Checked & Approved By : _____	
Comment : _____	
Additional Product	
Job Number: _____	
Seq. #: _____	Machine Or Operation: _____ Description : _____
1.0 QCS	INSPECT WORK TO CURRENT STEP
 	
Comment: INSPECT RTN 465	
2.0 POWDER COATING	POWDER COATING
 	
Comment: POWDER COATING STRIP POWDER COAT OFF SADDLES: 2 X D2571 B23801 / B24125 1 2 X D2572 B23801 / B24125 ✓ 2 X D2573 B24126 / B23509 1 2 X D2574 B24126 / B23802 →	
3.0 SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 	
Comment: SMALL & MEDIUM FAB RESOURCE 1 CHAMFER SADDLES BY HAND TO NEW REV. E ON ABOVE SADDLES	
4.0 QCS	INSPECT WORK TO CURRENT STEP
 	
Comment: INSPECT WORK TO CURRENT STEP	
5.0 POWDER COATING	POWDER COATING
 	
Comment: POWDER COATING TOUCH UP SADDLES WITH ALODINE POWDER COAT WHITE AS PER QSI 005 (REF. 4.3.5.1)	

1990

100

1. The first step is to identify the problem. This involves understanding the symptoms and the context in which they are occurring.

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

*[Faint, illegible handwritten notes]*



THE END



100-443882-1

7-9-75

1011-1012

Date: Friday, 3/24/2006 8:29:09 AM  
User: Linda Lacelle

## Process Sheet

Customer: EC-BARON Dart Aerospace Ltd.

Drawing Name: D2571/D2572/D2573/D2574

Job Number: 20374

Part Number: Z\_CUSTOM

Job Number:



Seq.:

Machine Or Operation:

Description:

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/12/14

7.0

PACKAGING

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

IDENTIFY & STOCK WITH NEW B/N'S

07/12/14 (8)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

07/12/14

Job Completion



U. 07.02.14

100

100-100

100-100

100-100

100-100

100-100

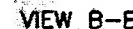
100-100




100-100

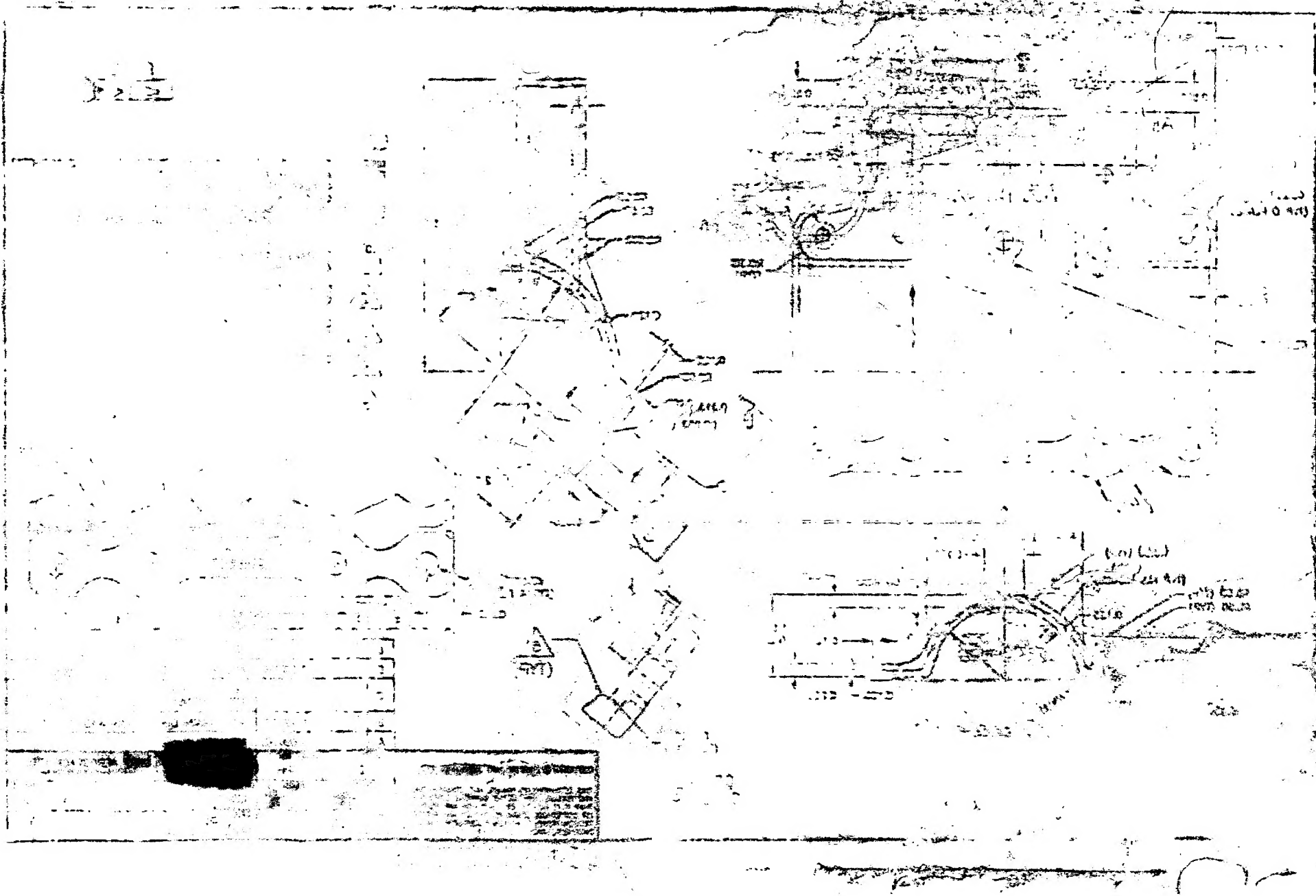
05-12-6

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. 06102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- $\triangle E$

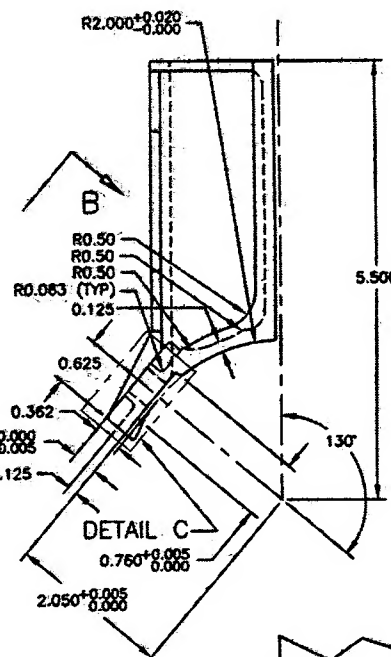
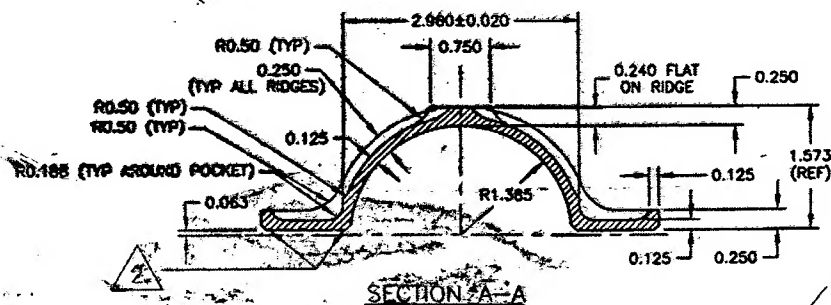
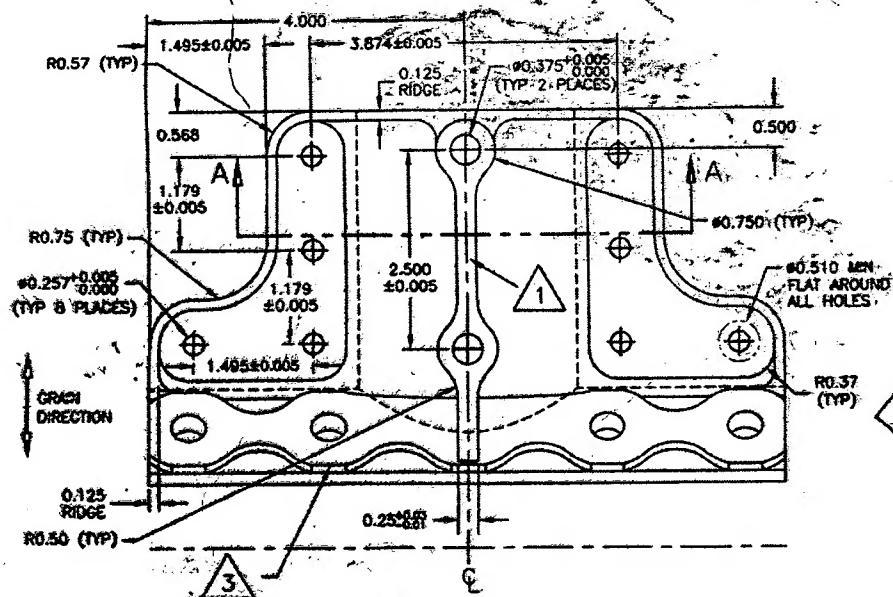


E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
<div style="display: flex; justify-content: space-between;"> <div> <p>DESIGN</p> <p>DS</p> <p>CHECKED </p> <p>DATE</p> </div> <div> <p>DRAWN BY</p> <p>PH</p> <p>APPROVED </p> </div> <div> <p></p> <p>DART AEROSPACE LTD. HARRINGTON, GUILDFORD, GU24 0HN</p> <p>DRAWING NO.</p> <p>D2571</p> <p>TITLE</p> <p>OUTER FWD SADDLE</p> </div> <div> <p>REV. 1</p> <p>SHEET 1 OF 2</p> <p>SCALE</p> <p>2:</p> </div> </div>		





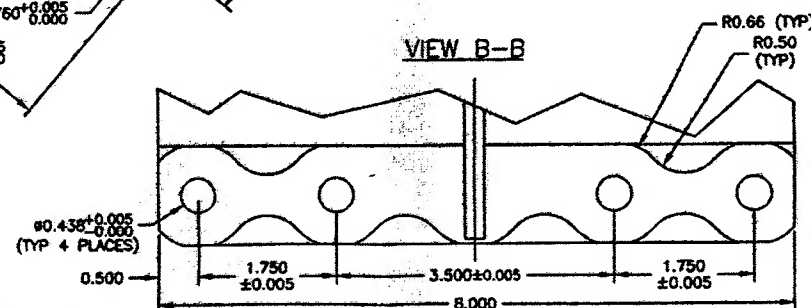
05.12.50






## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED


- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.053" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)
- E



DETAIL C  
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE LTD.</b> TORONTO, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO.
		D2572
DATE		TITLE
05.07.13		INNER FWD SADDLE
		REV.
		SHEET 1 OF
		SCALE
		2:

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

[illegible]

THE UNITED STATES OF AMERICA

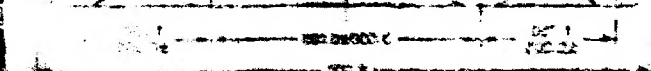
SECRET

2-26-54

14-00000

UNCLASSIFIED//FOR OFFICIAL USE ONLY

100-443886-1

[illegible]

1. The first part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

2. The second part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

3. The third part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

4. The fourth part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

5. The fifth part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

6. The sixth part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

7. The seventh part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

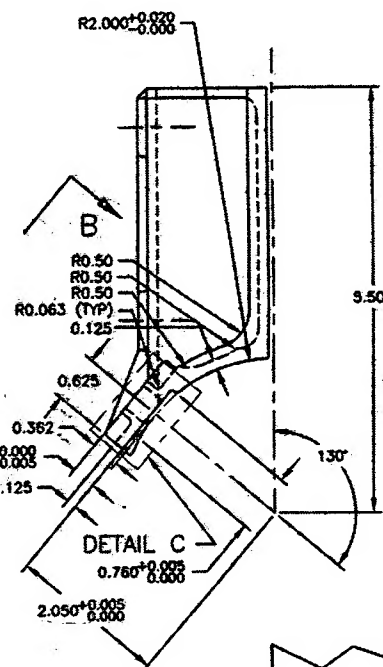
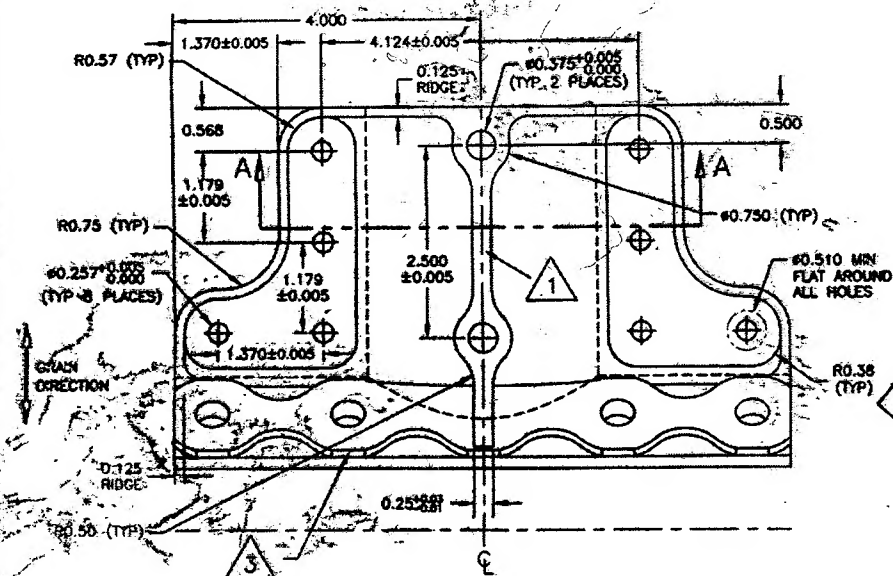
8. The eighth part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

9. The ninth part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.

10. The tenth part of the document is a list of names and addresses, which appears to be a directory or a list of contacts. The names are written in a cursive script, and the addresses are listed below them.







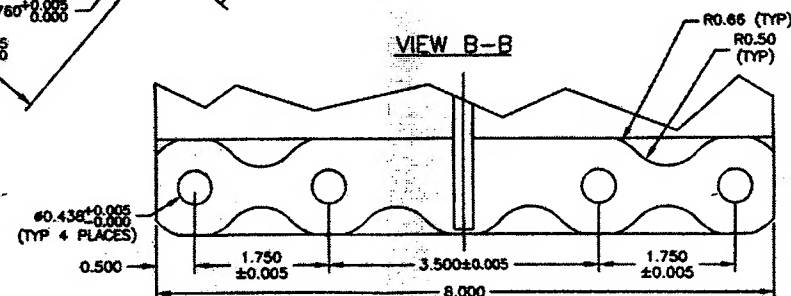
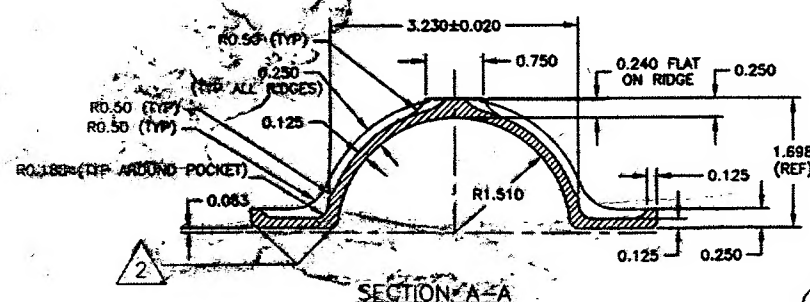
05.12.06



## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

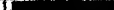


- |   |  |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
|  | CHAMFER 0.063 x 45° ALL AROUND                                   |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C)                               |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

1990年12月15日

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

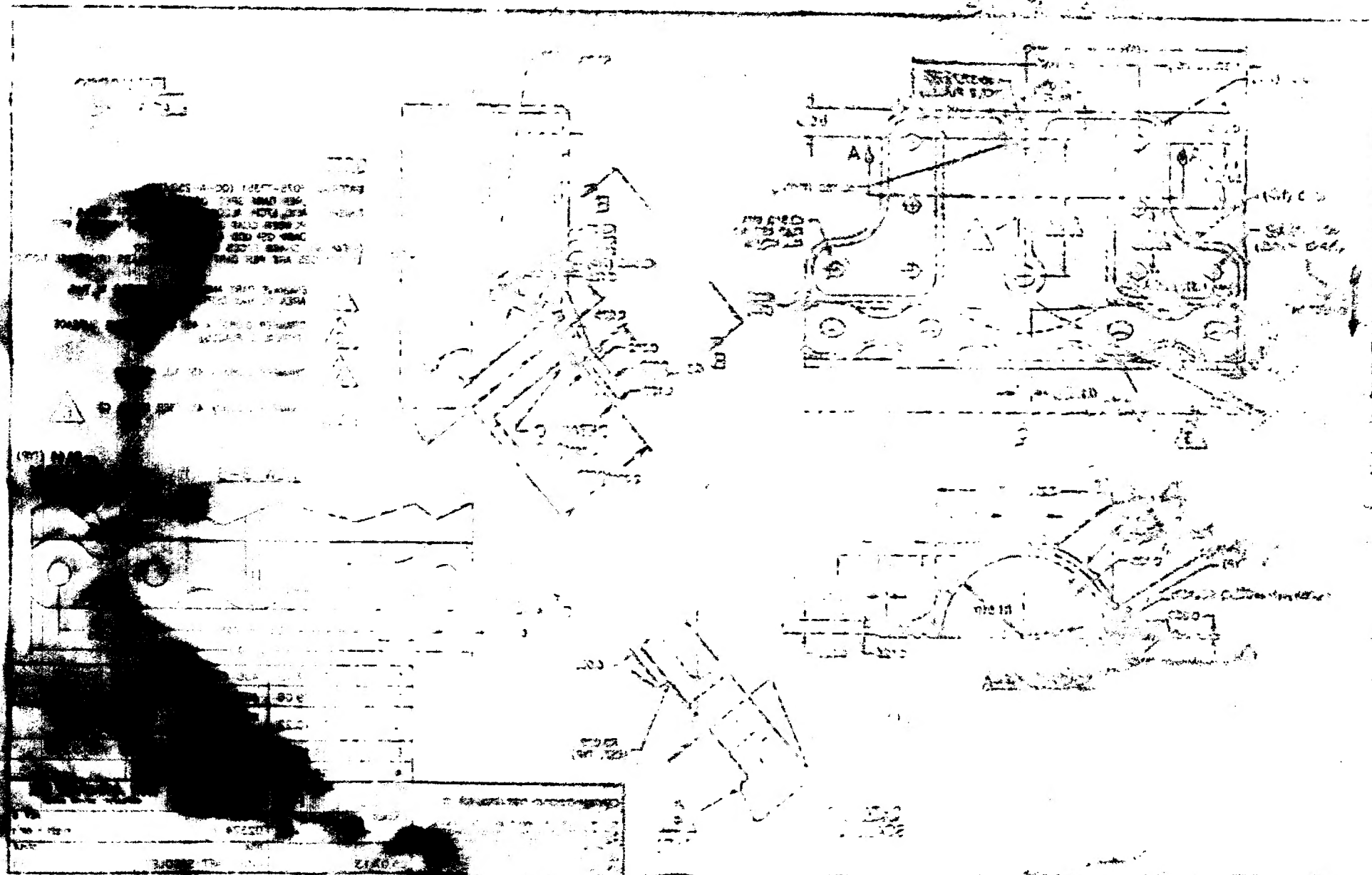
DESIGN	DRAWN BY	PART NO.	
DS	PH	 <b>DART AEROSPACE LTD.</b> <small>WILLOWDALE, ONTARIO, CANADA</small>	
CHECKED 	APPROVED 	QUANTITY NO. D2574	REV.
			SHEET 1 OF
DATE 05.07.13	TITLE INNER AFT SADDLE		SCALE 2:

REV.

SHEET 1 OF

SCN

2



# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070206	5.0	1x B24125 & 1x B24126 was left in the Acid over night, over etching the 2 saddles. Human error.	Q51042	Ensure employees stay on top: pay attention to work in progress. scrap: destroy the 2 <del>tools</del> <sup>saddles</sup>	FL 07/02/06	070206	Q51042	070206

NOTE: Date & initial all entries